

Date: Wednesday, 5/31/2006 7:36:20 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 27285					
Estimate Number	: 10517					
P.O. Number	: N/A		Part Number	: D28061		
This Issue	: 5/31/2006 S.O. No. : N/A		Drawing Number	: D2806 REV A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A		
Previous Run	: 26565		Material	: N/A		
Written By	: See comment below		Due Date	: 6/18/2006		
Checked & Approved By	: KJ/JLM 05/31/06		Qty:	40	Um:	Each
Comment	: Est:B 05.03.11 Part now turned KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6H1000	6061-T6 1" HexBar		
		Comment: Qty.: 0.0962 f(s)/Unit Total : 3.8472 f(s) 6061-T6 Hex Bar 1.0"	M19059 (23")	
		Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar (M6061T6H1.000)		Batch: M17030 J.G 06/06/05
2.0	HARDINGE	HARDINGE CNC LATHE SMALL		
		Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA105 and Dwg D2806 2-Tumble	J.G 06/06/05 42	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.G 06/06/05 42	
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Drill as per Dwg D2806	J.G 06/06/06 42	
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK	J.G 06/06/06 42	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/06/14

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date:
User:

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JAN

06:06:19 42

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

SP 06/06/13 42

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STB81

SP 06/06/13 42

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/13 42

Job Completion



SP 06/06/14 42

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design. Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27285
Description: Bushing	Part Number:	D2806-1
Inspection Dwg: D2806	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

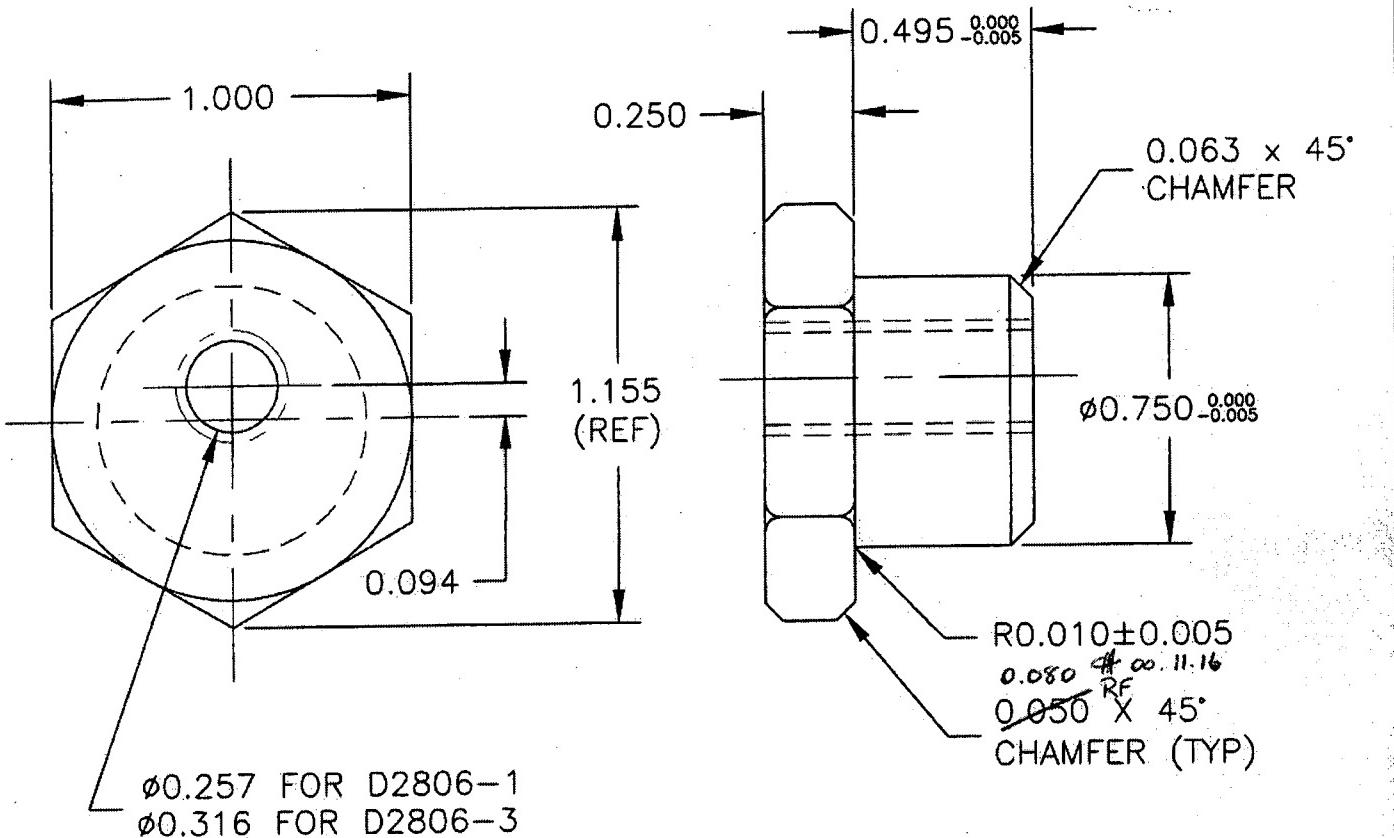
X First Article Prototype

Measured by:	<u>S.G</u>	Audited by:		Prototype Approval:	N/A
Date:	<u>06/06/05</u>	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	JF

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
CP		D2806	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.08		BUSHING	2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13

D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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 WORK ORDER
 NO. 27285

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